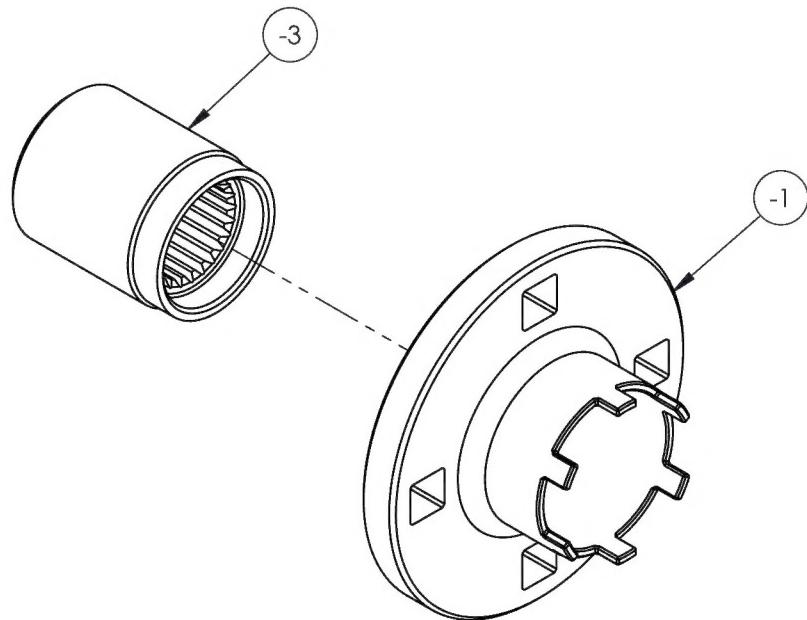


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/8/2016	RJC	JAG



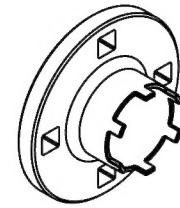
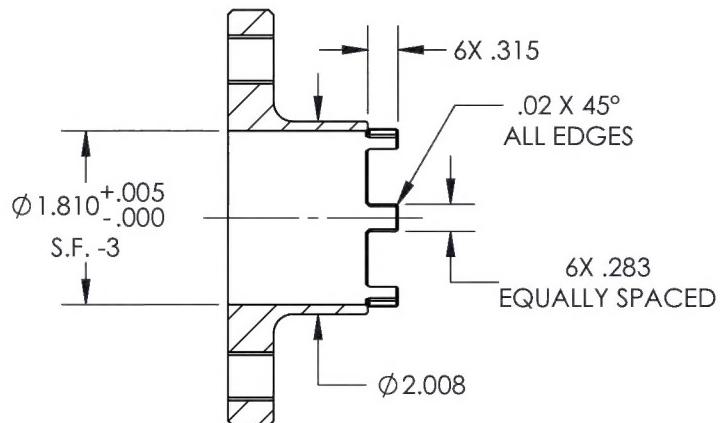
NOTE:
REF. AGUSTA T/N: 109-3130-51-101.

DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101 REV 1	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:2
DATE	7/24/2013
USED ON MODEL	

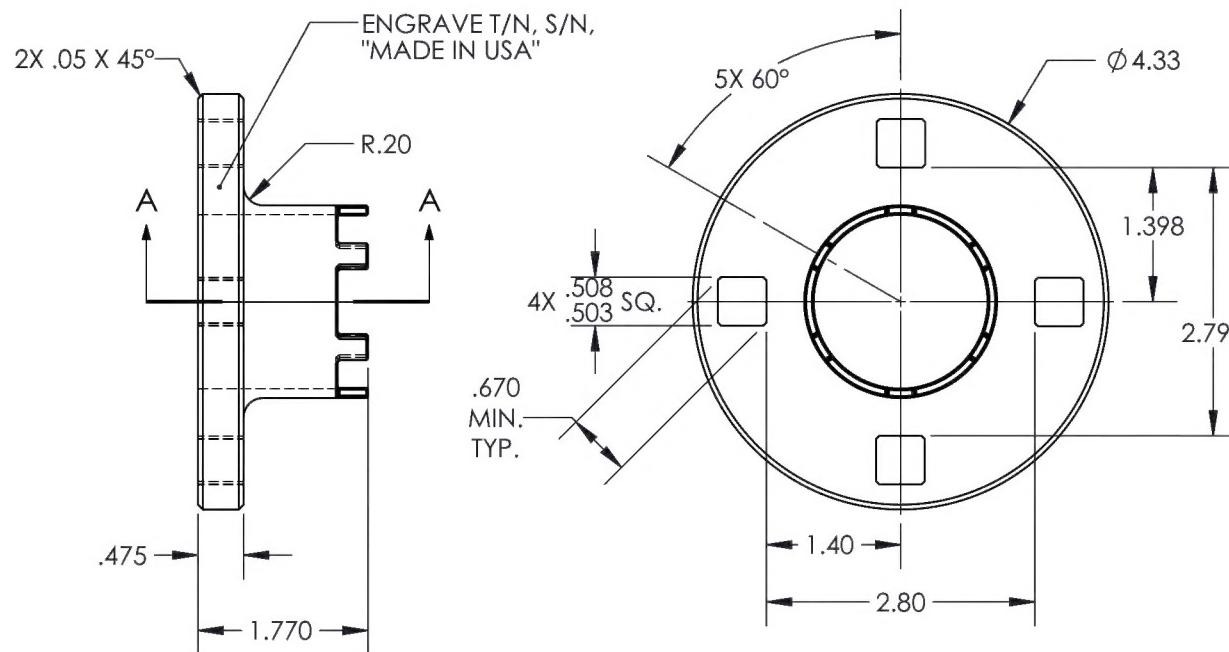
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
		-1	1		KEY, LOCKING	4140/4142 Q & T		2
		-3	1		WRENCH CENTERING	4140/4142 Q & T		3

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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SECTION A-A



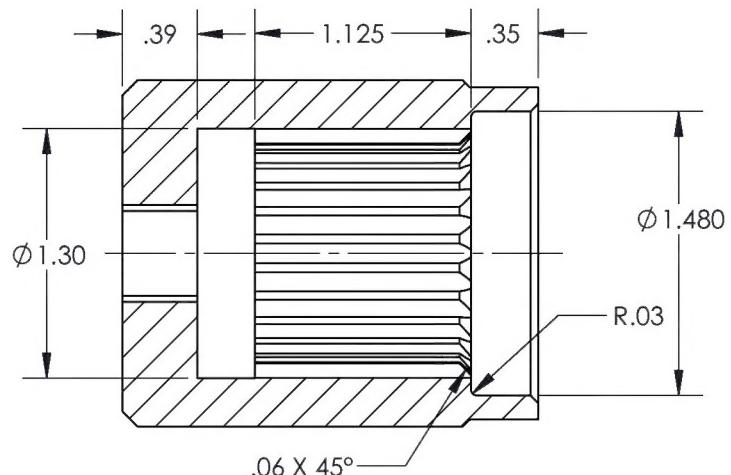
(-1)

KEY, LOCKING

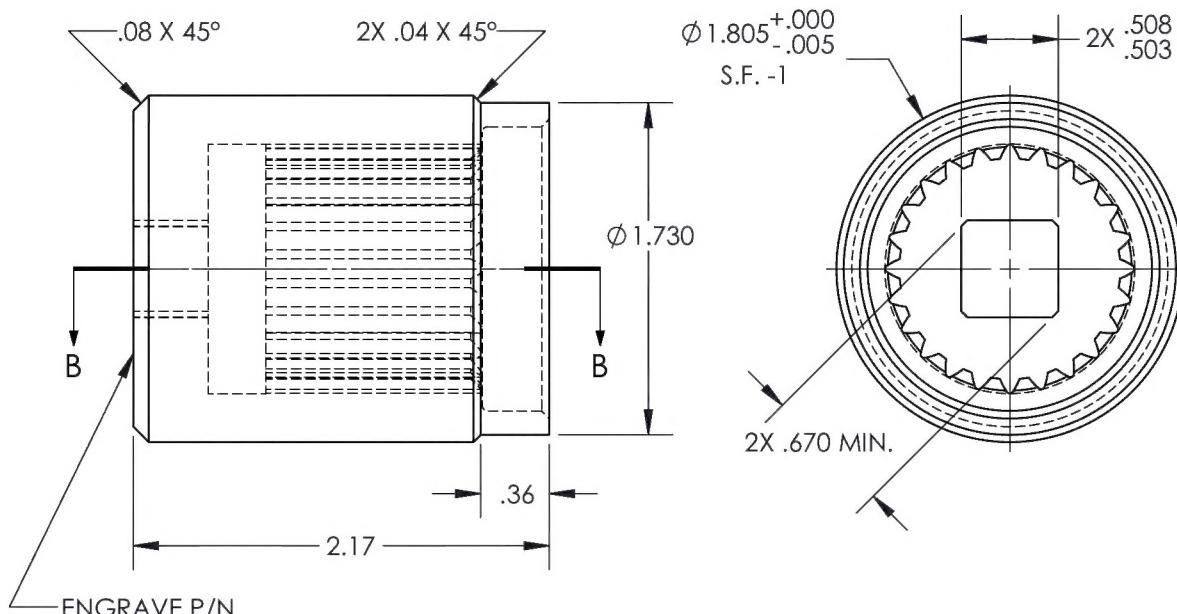
DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101-1 REV 1	
MATERIAL 4140/4142 Q & T UNLESS OTHERWISE SPECIFIED HEAT .XXX ± .005 DIMENSIONS ARE IN INCHES TREAT .XX ± .01 FRACTIONS ± 1/8 FINISH ZINC PLATE ANGLES ± 5° SPEC ASTM B633 TYPE I SC 2 SURFACES = 125 ✓ DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY USED ON MODEL APPROVED: GILBERT AW109 SCALE 1:2 DATE 7/24/2013 SHEET 2 OF 3	

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REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	

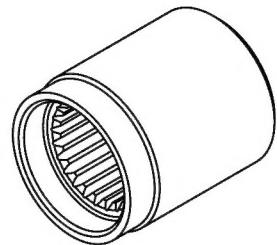


SECTION B-B



WRENCH CENTERING

(-3)



INTERNAL SPLINE DATA	
STANDARD	ANSI B92.1-1996
ROOT & FIT	FILLET ROOT SIDE FIT
NUMBER OF TEETH	24
DIAMETRAL PITCH	20/40
PRESSURE ANGLE	30°
MAJOR DIAMETER	1.2900 - 1.3049
MINOR DIAMETER	1.1500 - 1.2540
DIA. OVER Ø.0864 PINS	Ø1.0778 - 1.0803
TOLERANCE CLASS	CLASS 5 FIT

DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101-3 REV 1	
MATEL 4140/4142 Q & T UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT FRACTIONS $\pm \frac{1}{16}$ FINISH .XXX $\pm .005$ ZINC PLATE .XX $\pm .01$ ANGLES $\pm 5^\circ$ SPEC B633 TYPE I SC 2 .X $\pm .1$ SURFACES = 125 DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT USED ON MODEL AW109 SCALE 1:1 DATE 7/24/2013 SHEET 3 OF 3	